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D4775-041
Job Sheet 180889



Part No: D4775-041

Job Qty: 10 ea

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/17/18

Job Tracking No:

Due Date: 7/27/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEET 1 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.08.26 PB1 DD VERF:JLM IPP REV:C 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:D 14.01.10 AS PER REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	7/27/18	7/27/18	0.00	0.00	Start Up Stores/Pkg-1		OCT 02 2018
110	Packaging	10 pcs	7/27/18	7/27/18	0.00	0.00	Packaging1-5		OCT 02 2018
120	Small Fab	10 pcs	7/27/18	7/27/18	0.00	4.15	Small Fab-7		OCT 02 2018
130	QC	10 pcs	7/27/18	7/27/18	0.00	0.00	QC5		OCT 03 2018
140	Packaging	10 pcs	7/27/18	7/27/18	0.00	0.00	Packaging3-2		OCT 03 2018
150	QC21-SA	10 Ea	7/27/18	7/27/18	0.00	0.00	QC21		OCT 03 2018

Part Op 120 - 1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG A/R PROSEAL
Descriptions: BATCH: _____ 2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

DAS
21
9-89
OCT 03 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-10A	Bolt	20 Ea (2 ea)	90-Start up Operation	5089298
D4775-1	Strut Tube	10 Ea (1 ea)	90-Start up Operation	5150806
D4776-1	Basket Strut Clevis	10 Ea (1 ea)	90-Start up Operation	5103382
D4776-5	Spacer	40 Ea (4 ea)	90-Start up Operation	5002231
D4777-1	Rod End Bearing	10 Ea (1 ea)	90-Start up Operation	5193382
MS21042L3	Nut	20 Ea (2 ea)	90-Start up Operation	5094592
MS21209-F615	Heli-Coil	10 Ea (1 ea)	90-Start up Operation	5105838

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-10A	20	293	0
	D4775-1	10	11	0
	D4776-1	10	21	0
	D4776-5	40	40	0
	D4777-1	10	40	0
	MS21042L3	20	3,011	0
	MS21209-F615	10	118	0

Part Specifications

Specifications could not be found.

Plex 10/2/18 9:12 AM dart.quirion.sonia

md 14 June 2019 ✓



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7124 Route update only ☐

Job: <u>180889</u>		DISPOSITION				DEPARTMENT/PROCESS										
Part No. <u>2477001</u>		Rework ☐ Scrap ☐ Use-as-is ☒				Eng. (Non-AW) Prod. Eng. Coord. ☒ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐										
Date: <u>16/10/13</u>	Sequence #: <u>120</u>	QTY Affected: <u>2</u>		MRB (QSI042) DAS 12 16/10/13 9-89		Completed By DAS 12 16/10/13 9-89 Lead hand / Supervisor DAS 9 9-89 QC / QA Coordinator DAS 9 9-89 13-10-03										
Description Work Order Deviation <u>Ø 0.05" witness hole is ± 45° from intended plane</u>						Disposition <u>Acceptable. No effect on strength or function of witness hole.</u>										
Root Cause		FAULT CATEGORY														
☒ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☒ Drill Holes ☐ Fit/Function					☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up					☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread				
Other/Details:																